

That which is claimed:

*Subj* 1. A method of making a hollow fiber membrane contactor comprising the steps of:

winding a hollow fiber fabric around a center tube,  
potting the fabric and the tube together *using a first potting material*

forming thereby a unitized structure,

*unitized*  
placing the structure into a shell,  
potting the structure and the shell together, and *forming a mold* *by setting* *second potting material* *in the space between the structure & the shell*

forming thereby a cartridge.

2. The method of claim 1 wherein the first-mentioned potting being bead potting.

3. The method of claim 1 wherein the second-mentioned potting being mold potting.

4. The method of claim 1 further comprising the step of heat-treating the cartridge.

5. The method of claim 4 wherein the heat-treating further comprises a first heat-treating and a second heat-treating.

6. A hollow fiber membrane contactor comprising:  
a unitized structure comprising  
a center tube,  
a hollow fiber fabric wound around said tube, and  
a first potting material joining together said  
fabric and said tube;  
a shell; and  
a second potting material joining together said structure  
and said shell.

7. The contactor of claim 6 wherein said structure having a  
diameter of six (6) inches or more.

8. The contactor of claim 6 further comprising end caps  
located at end portions of said shell.

9. The contactor of claim 6 wherein the first potting  
material and the second potting material are the same.

10. The contactor of claim 6 wherein the potting material is  
selected from the group consisting of thermosetting materials and  
thermoplastic materials.

11. The contactor of claim 10 wherein the thermosetting materials are selected from the group consisting of epoxy and polyurethane.

12. The contactor of claim 10 wherein the thermoplastic materials are selected from the group consisting of polyolefins and polyurethanes.

13. The contactor of claim 5 further comprising a fabric spacer, said spacer adapted for maintaining said fiber of said fabric in a uniform and spaced apart fashion.

14. A system of contactors for degassing a liquid comprising at least two contactors coupled together, one said contactor being the contactor of claim 6.

15. The system of claim 14 wherein said structure having a diameter of 6 inches or greater.